

TO REPLACE LID ON D130-701-041 83018

Work Order ID 86224

\*86224\*

Page 1

June-25-12 10:05:19 AM

Item ID: D2512 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Basket Lid 205/350  
Start Date: 6/25/12 Start Qty: 1.00 \*1\* Cust Item ID:  
Required Date: 6/29/12 Req'd Qty: 1.00 \*1\* Customer:  
Reference:

Approvals: Process Plan:   *W*   Date:            Tooling:            Date:            Run Start \*NR1\*  
QC:            Date:            SPC (Y/N):            Date:            Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2512	Rev E								
100	Weld per dwg A/R S.S. rod Batch: <u>11/816</u>	0.00							
*100*	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut 3/4" x 3/4" square tubing as per Dwg D2512								
	2-Cut (4) D2236 From D3166-3								
	3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305								
	4-Weld as per Dwg D2512 using Welding Jig DT 9436								
	Deburr as required								
	***INSTALL D2012-117 CLEVIS ONLY ON <u>D130-701-041</u> *** <u>yes</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

(1x)

12-06-27

1x

12-06-27

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**\*86224\***

Page 2

June-25-12 10:05:19 AM

Item ID: D2512 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>	<b>QC5</b>	0.00							
QC	Memo								
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
<b>*125*</b>		0.00							
HandFinish	Memo								
Hand Finishing									

Handwritten notes: 8/7/06/122, 1 6, 12-0-27

Page 3

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4  
Batch: *D1613*

1 0 14-6-57

10 ~~134~~ 12-6-78

Work Order ID 86224

\*86224\*

Page 4

June-25-12 10:05:19 AM

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 Revision ID: Stop \*NS2\*  
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Start Date: 6/25/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 6/29/12 Req'd Qty: 1.00 \*1\* Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
*150*									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location <u>D/30-70-04B.</u>	0.00							
*160*									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
*170*									
QC	Memo	0.00							
Quality Control									

1 0 126-8.

126/28

MF  
12-06-28

# Picklist Print

June-25-12 10:05:17 AM

Page 1

Work Order ID: 86224

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 6/25/12

Required Date: 6/29/12

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF  
 IPP Rev:N06.04.05 Added level21 EC  
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM VERIFIED BY:DD  
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified by:EC  
 DD verf:EC IPP Rev:R 10.06.29 added pressure wash

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-117 Clevis		Manufactured	No			100	Each	35.0000	2	2		CC 12-6-25	
*** ONLY APPLICABLE ON D130-701-041 -IF NOT USED, PLEASE MARK N/A ***				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		35							
				55729		4							
				69890		31							
D2232-1 Basket Hinge		Manufactured	No			100	Each	12.0000	2	2		CC 12-6-25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		12							
				78992		10							
				79472		2							
D2327-1 Spacer Bushing		Manufactured	No			100	Each	29.0000	2	2		CC 12-6-25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		29							
				69728		3							
				73692		26							
D2506 Label Plate		Manufactured	No			100	Each	14.0000	1	1		CC 12-6-25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		14							
				79197		3							
				82705		11							

# Picklist Print

June-25-12 10:05:18 AM

Page 2

Work Order ID: 86224

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 6/25/12

Required Date: 6/29/12

Start Qty: 1.00

Required Qty: 1.00

D2581  
Mounting Bracket

Manufactured No

100 Each 81.0000

2

2

CC 12-6-25

Location

Loc Qty

Loc Code

WA	49	
82506	2	
83230	3	
85436	20	
85452	24	
WA005	32	
70766	2	
81253	1	
82897	29	

D3166-3  
Basket Hoop

Manufactured No

100 Each 7.0630

1

1

CC 12-6-25

Location

Loc Qty

Loc Code

WA	6.4842	
84713	0.8632	
84713	5.621	
WA007	0.5788	
77294	0.5788	

M304EX0.75-16F  
Expanded Metal Flat SS

Purchased No

100 sf 870.6152

18

18.947368

CC 12-6-25

Location

Loc Qty

Loc Code

WA	4.9094	
121738	4.9094	
WA035	865.7057637	
117197	102.9036	
120917	101.57273	
121521	0.00013372	
121849	21.2293	
122080	320	
122138	320	

18.9474

June-25-12 10:05:18 AM

Shop Packet Print

Page 2

# Picklist Print

June-25-12 10:05:18 AM

Page 3

Work Order ID: 86224

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 6/25/12

Required Date: 6/29/12

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100 f

1,384.9169

43.5804

45.874105

CC 12-6-25

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Lor Code

MAT

1000

112398

0

122051

1000

MAT017

343.9169370

120267

26.9468670

120633

316.97007

MAT018

41

7636

41

45.8742

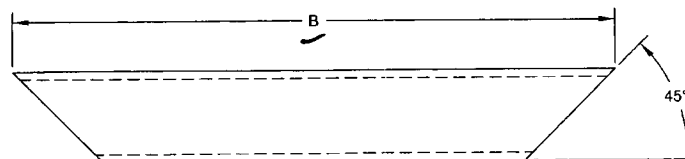
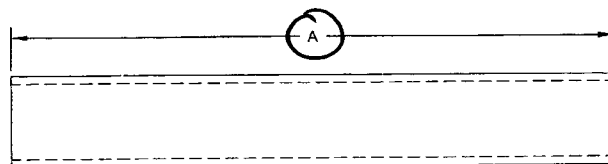
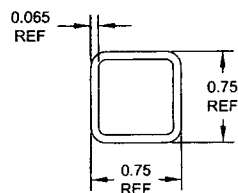
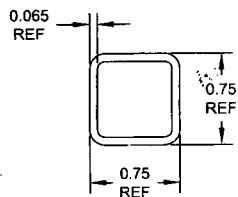
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Page 3

# **PARTS LIST FOR D2512 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH <u>A</u>	LENGTH <u>B</u>	DESCRIPTION
D2512-1	2	—	25.50	RIB ✓
D2512-3	2	—	95.30	RIB ✓
D2512-5	6 ✓	30.84	—	RIB ✓
D2512-7	3	30.63	—	RIB ✓
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



**RELEASED**  
08-08-21-11

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.080 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO 'B' FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1985 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

## **D2512-1/-3/-5/-7 NOTES:**

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82165

*86224*

*101703-23*



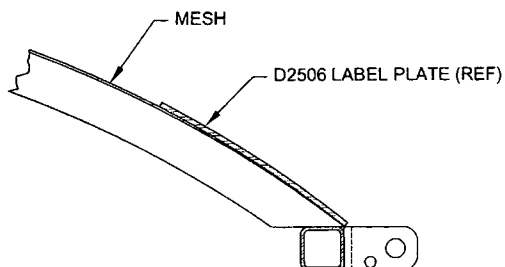
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**SECTION A-A<sub>B3-2</sub>**  
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED

SKIN OUTSIDE SURFACE OF LID WITH  
3/4-16F EXPANDED SS. TACK WELD  
EACH END STRAND TO FRAME

SEE DETAIL B FOR  
FRAME ASSEMBLY

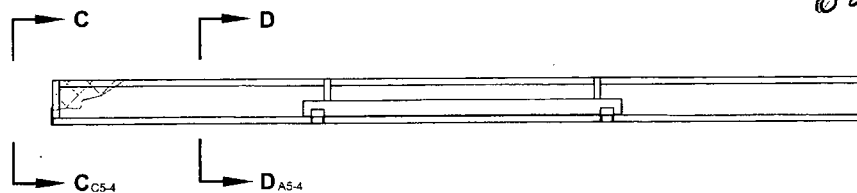
D2506 LABEL PLATE  
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE



**D2512 BASKET LID ASSEMBLY NOTES:**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



**RELEASED**  
05 05 21/11

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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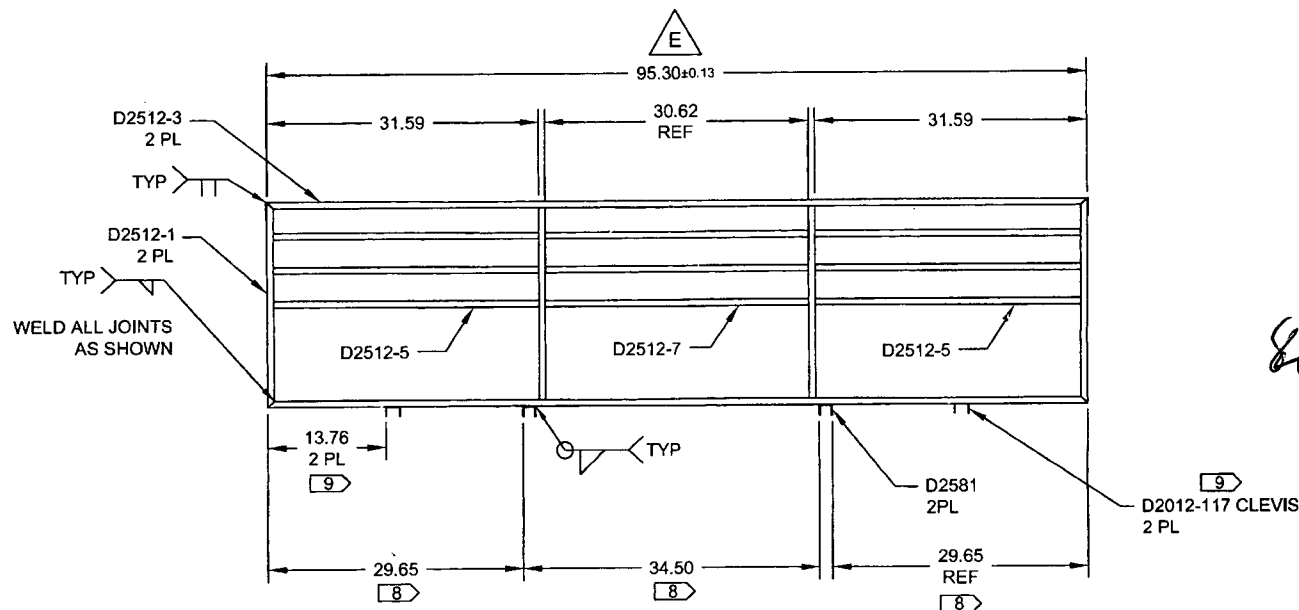
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

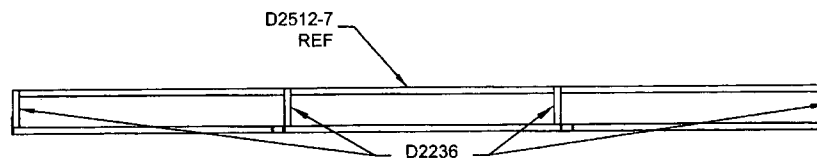
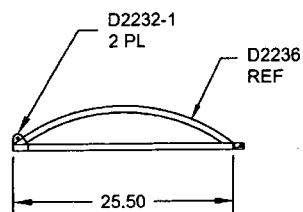
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DETAIL B** C3-2  
FRAMEWORK ONLY SHOWN FOR CLARITY



**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	N	D2512	SHEET 3 OF 4
APPROVED	JP	TITLE	SCALE
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08 06 17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

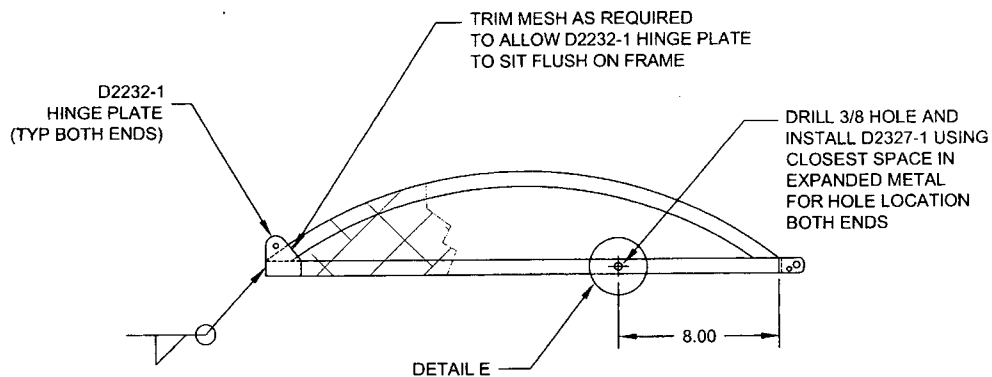
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

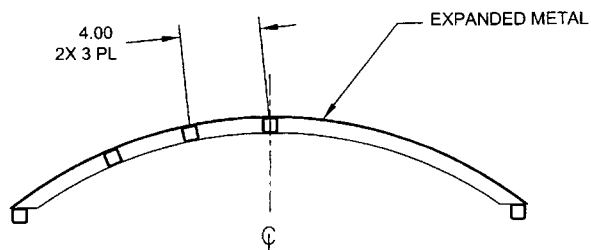
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

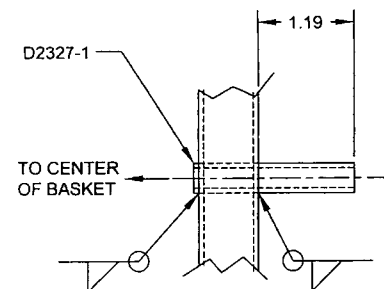


**VIEW C-C SIMILAR BOTH END RIBS** A5-2



**SECTION D-D SAME BOTH CENTER RIBS** A4-2

86224  
82165



**DETAIL E** C6-4

**RELEASED**  
08-06-21/17

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries